

Work Order ID 129352

February-04-15 11:18:36 AM

129352

Page 1

Item ID: D5204-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Bracket

Stop *NS2*

Start Date: 2/04/15 Start Qty: 12.00

12

Cust Item ID:

Required Date: 2/13/15 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D5204

A

100

0.00

100

BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks at 2.50"

on 15/02/05 12 10

DAS
14
9-89

110

0.00

110

HAAS CNC VERTICAL MACHINING #1

HAAS 5AXIS

Memo

0.00

HAAS CNC vertical machine #5

Machine per folio FB362

Folio rev: AA

Dwg. rev: A

on 18/02/05 12 10

DAS
14
9-89

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Page 3

Item ID: D5204-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bracket
 Start Date: 2/04/15 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 2/13/15 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
165	QC7-Inspect Chemical Conversion Coat	0.00							
165									
QC	Memo	0.00							
Quality Control									
170	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
170									
Powdercoat	Memo	0.00							
Powder Coating	-Mask holes as per dwg.								
	START TIME: 10:05 OVEN TEMPERATURE:								
	FINISH TIME: 10:35								
180	QC3- Inspect Part Finish	0.00							
180									
QC	Memo	0.00							
Quality Control									

FEB 13 2015

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Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Bracket

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Start Date: 2/04/15 **Start Qty:** 12.00

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Cust Item ID:

Required Date: 2/13/15 **Req'd Qty:** 12.00

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Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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190

Identify as per dwg & Stock Location: St 151

0.00

190

Packaging

Memo

0.00

Packaging

12

DAB
06
9-69

FEB 18 2015

200

QC21- Final Inspection - Work Order Release

0.00

200

QC

Memo

0.00

Quality Control

15/2/18

A15.2-18

Picklist Print

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Page 1

Work Order ID: 129352

129352

Parent Item: D5204-1

D5204-1

Parent Item Name: Bracket

Start Date: 2/04/15

Required Date: 2/13/15

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev: A RQ 15.01.15 verified by: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B2.500X03.50 0		Purchased	No			100	f	13.3760	0.208	3			

M6061T6B2 500X03 500

6061-T6 Bar 2.50 x 3.50

**

Location

Loc Qty

Loc Code

MAT004

13.376

→ m126724

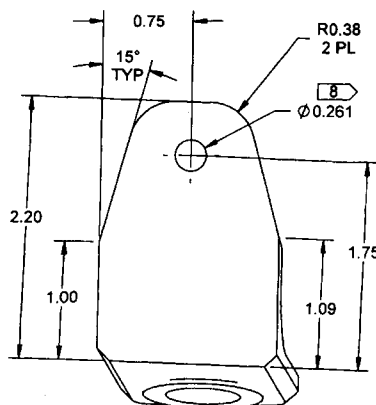
1.376

→ m129530

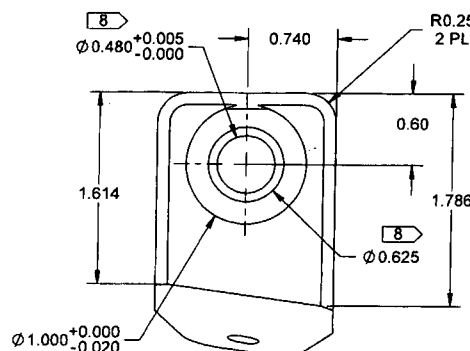
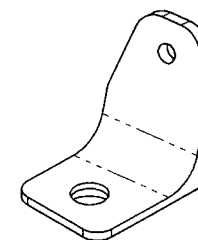
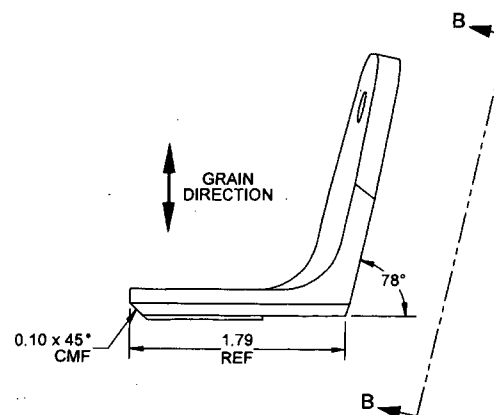
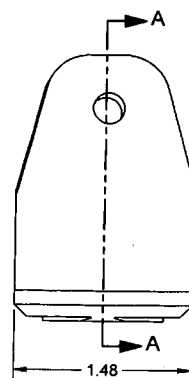
12

1.376
1.624
+ .208

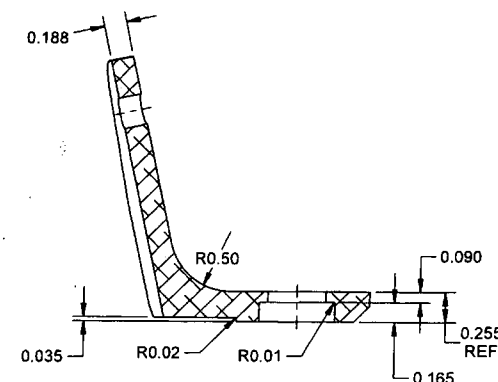
OK 15/02/15



VIEW B-B



D5204-1 BRACKET



SECTION A-A

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.10 lbs
- 8) MASK HOLES PRIOR TO POWDER COAT

RELEASED

2015 JAN 29

ECN 15-508 4P

APPROVED

A	NEW ISSUE	RF	14.12.19
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	AK	DRAWING NO.	REV. A
MFG. APPR.	RQ	D5204	SHEET 1 OF 2
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	BRACKET	NTS
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